

Work Order ID 99717

April-11-13 2:56:40 PM

99717

Page 1

Item ID: D2360
Revision ID:
Item Name: Litter Tie Down Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 4/11/13 Start Qty: 4.00 ***4***
Required Date: 4/11/13 Req'd Qty: 4.00 ***4***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *MLJ* Date: *13-04-15* Tooling:
QC: Date: SPC (Y/N):

Date:
Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2341	Rev F ✓								
D2360	Rev D ✓								
100	BAND SAW	0.00				8	0		SL 13-4-23
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 12.65" Long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110						8	1		SL 13-4-24 25
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio D2341 and Dwg D2341 2-Deburr								PHC →

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Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 4/11/13 Start Qty: 4.00

Required Date: 4/11/13 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

Accept ***N900040100***

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

8 1 JL 13-4-24

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

OK 13/04/24

8 1

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

8 13-4-25

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Item ID: D2360

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Litter Tie Down Assembly

Stop

NS2

Start Date: 4/11/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/11/13

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

START TIME: 10:00

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:30

0.00

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

170

Small Fab

0.00

170

Small Fab

Small Fab

Memo

Assemble as per dwg D2360

0.00

Drill # D / Q31042
246 / 13-1001

8X M / 13/24/26

2x 1 All 13/24/26

5x

3x

3/10/08

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Item ID: D2360

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Litter Tie Down Assembly

Start Date: 4/11/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 4/11/13 Req'd Qty: 4.00 *4*

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: Date:

Tooling: Date:

Stop *NR2*

QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

27

9-89

0.00

130.8

5

180

QC

Memo

Quality Control

190

Identify as per dwg & Stock Location: ST221 0.00

0.00

0.00

190

Packaging

Memo

Packaging

13/10/9 (5)

DAS
32
9-89

200

QC21- Final Inspection - Work Order Release 0.00

0.00

0.00

200

QC

Memo

Quality Control

JA / Rm 13/10/10

MF
13-10-10

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Parent Item Name: Litter Tie Down Assembly

Required Date: 4/11/13

Required Qty: 4.00

Comments: IPP rev H 07.06.12 ecn 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R18 Screw		Purchased	No			170	Each	593.0000	1	4		4/13/10/08	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	93	
4523	93	
ST346	500	
108079 —	400	
110099	100	

AN960JD10 Washer	NAS1149D0363J Purchased 10X
AN960JD10L Washer	NAS1149D0332J Purchased 40X
D2002-015 Knob	Manufactured No

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	45	
98241	20	
98570	25	

D2345	Manufactured	No
Lock Channel		

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	11	
86349	11	

D2366	Manufactured	No
Lock Handle		

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST009	12	
86351	2	
95770	10	

Per Kit	Total Qty	Qty Issued	Date Issued	Status
1	4	4	13/10/08	
	85	8	13/10/08	
2	8	32	13/10/08	
8	2	8		
			13/10/08	
	1210	1	13/10/08	
		4	13/10/08	
			B99626	
			B100800	5x
2	8	8	13/10/08	
			B100836	10x
			B102827	
			60	

Picklist Print

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Work Order ID: 99717
Parent Item: D2360
Parent Item Name: Litter Tie Down Assembly

Start Date: 4/11/13
Start Qty: 4.00

Required Date: 4/11/13
Required Qty: 4.00

D2367 Manufactured No
Handle Knob

170 Each 23.0000 1

4 13/10/08

Location	Loc Qty	Loc Code
ST009	23	
89083	3	
95711	20	

35

* D2372
Quick Release

Manufactured No

170 Each 19.0000 2

8 13/10/08

Location	Loc Qty	Loc Code
GA	19	
86001	2	
95177	5	
97848	12	

~~B99810~~ B99810 (1x) B105402 (1x)

D2373 Manufactured No
Spring

170 Each 9.0000 1

4 13/10/08

Location	Loc Qty	Loc Code
ST009	9	
86352	9	

B98341 (5x)

D2444
Pip Pin Assembly

Manufactured No

170 Each 12.0000 1

4 13/10/08

Location	Loc Qty	Loc Code
ST010	12	
97238	1	
98455	11	

B105573 (1x) B105573 (2x) B101027 (4x)

D6201 Manufactured No
"T" Extrusion

100 f 57.9186 1.054 4.4378948

SL 13-4-23

Location	Loc Qty	Loc Code
MAT028	57.91863153	
81421	4.61863153	
83987	20	
89645	13.3	
96808	20	

89

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Shop Packet Print

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Picklist Print

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Page 4

Work Order ID: 99717

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 4/11/13

Required Date: 4/11/13

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-15 Purchased No

170 Each 967.0000 2 8

Screw

Location

Loc Qty

Loc Code

ST506

967

124326 -

967

170

Each

174.0000

1

4

Location

Loc Qty

Loc Code

GA

5

1463

5

2409

169

NAS679A3W
Nut

Purchased No

4/23/10/08
M124326 (10x)
4/23/10/08
~~M124326~~
(3x)

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Shop Packet Print

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DART AEROSPACE LTD		Work Order:	
Description: Litter Tie Down Bracket (Locking)		Part Number:	D2341
Inspection Dwg: D2341	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

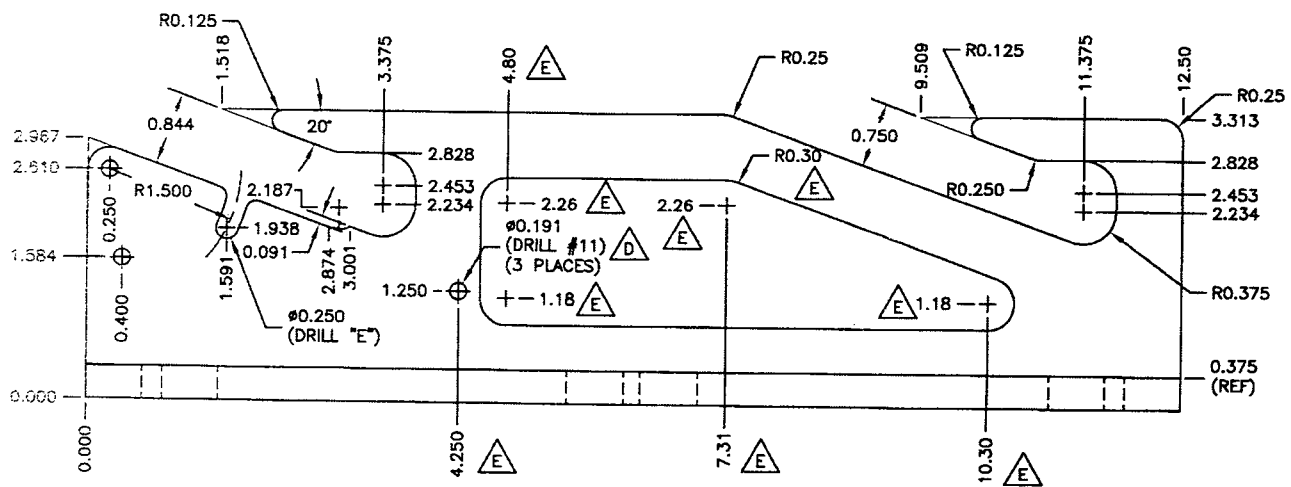
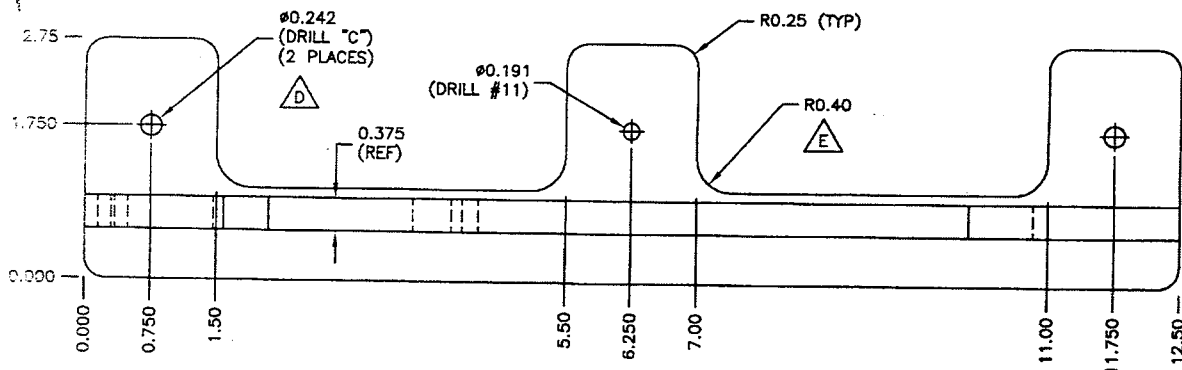
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.744	✓		vern	SL-10
2.75	+/-0.030	2.755	✓		-	
Ø0.242	+0.005/-0.001	.242	✓		-	
Ø0.191	+0.005/-0.001	.191	✓		-	
R0.25	+/-0.030	.250	✓			
R0.40	+/-0.030	.400	✓			
12.50	+/-0.030	12.505	✓		H-G	
11.750	+/-0.010	11.750	✓		vern	CNC-02
11.00	+/-0.030	11.003	✓		H-G	
7.00	+/-0.030	7.004	✓		H-G	
6.250	+/-0.010	6.251	✓		vern	CNC-02
5.50	+/-0.030	5.503	✓		H-G	
1.50	+/-0.030	1.505	✓		vern	SL-10
0.750	+/-0.010	.753	✓		-	
0.400	+/-0.010	.400	✓		-	
1.584	+/-0.010	1.584	✓		-	
2.610	+/-0.010	2.610	✓		-	
0.250	+/-0.010	.249	✓		-	
0.844	+/-0.010	.844	✓		-	
Ø0.250	+/-0.010	.251	✓		-	
0.750	+/-0.010	.751	✓		-	
3.313	+/-0.010	3.314	✓		-	
4.250	+/-0.010	4.250	✓		-	
1.250	+/-0.010	1.249	✓			

Measured by: SL	Audited by: [Signature]	Prototype Approval:	N/A
Date: 13-4-23	Date: 13/04/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	[Signature]

DART

DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	

**D2341 LITTER TIE DOWN BRACKET (LOCKING)**

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION
(6061-T6/T651 PER QQ-A-200/B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT
PERMANENT INK MARKER

**RELEASED**

07-06-22

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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

RELEASED

07 06 07

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

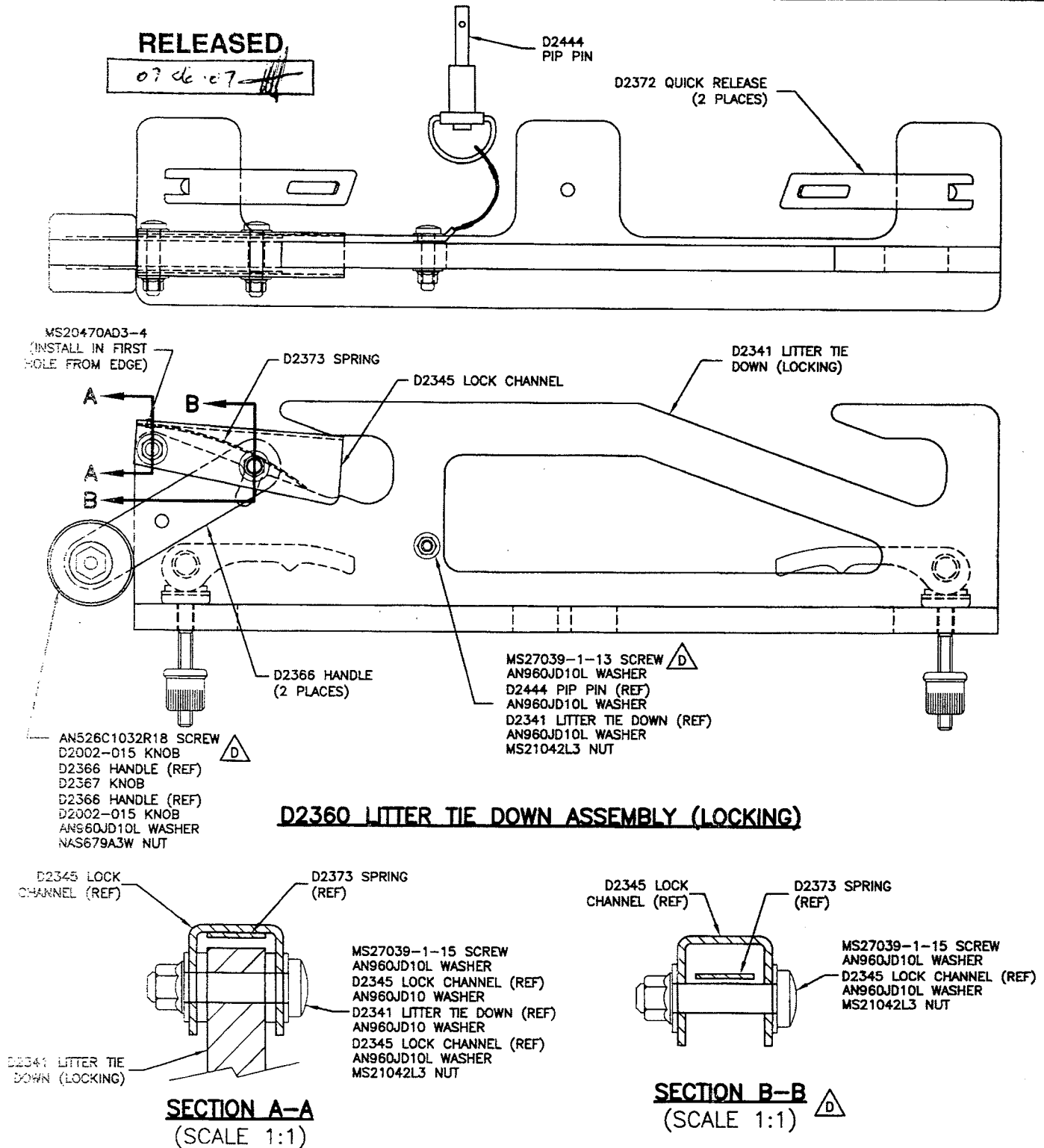
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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2360	REV. D SHEET 2 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	



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